

4693



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBA9928-19

Job Sheet 177145



Part No: RBA9928-19

Job Qty: 1 ea

Part Name: Rig Fixture, Lateral Cyclic



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/8/18

Job Tracking No:

Due Date: 6/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBA9928-19 Rev. 5A IPP Rev. A 18.05.07 new issue DP Verify DD

Ship Via:

SHIP
6-25
7-13

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	1 Ea	6/20/18	6/20/18	0.00	0.00	Start Up Large Fab-7		EC
110	Large Fab	1 pcs	6/20/18	6/20/18	0.00	1.00	Large Fab 1		EC
120	QC	1 pcs	6/20/18	6/20/18	0.00	0.00	QC9		EC
130	QC	1 pcs	6/20/18	6/20/18	0.00	0.00	QC5		EC
150	Small Fab	1 pcs	6/20/18	6/20/18	0.00	0.10	Small Fab-3		EC
155	QC	1 pcs	6/20/18	6/20/18	0.00	0.00	QC5		EC
160	Packaging	1 pcs	6/20/18	6/20/18	0.00	0.00	Packaging3-2		EC
170	QC21-FG	1 Ea	6/20/18	6/20/18	0.00	0.00	QC21		EC

Part Op 110 - Weld as per DWG.

Descriptions: 150 - 1-Assemble as per DWG.

160 - Bag and label

18-7-31
9-86
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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBA9928-19-1	Plate	1 Ea (1 ea)	100-Start up Operation	5090842
RBA9928-19-3	Lug	1 Ea (1 ea)	100-Start up Operation	5094158
RBA9928-19-7	Button	1 Ea (1 ea)	100-Start up Operation	5089369
92994A40255	Acorn Nut	1 Ea (1 ea)	150-Small Fab	5070272
RBA9935	Draw Bolt	1 Ea (1 ea)	150-Small Fab	5089591
V-1	Thumb Nut	1 Ea (1 ea)	150-Small Fab	5097993

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	RBA9928-19-1	1	0	0
	RBA9928-19-3	1	0	0
	RBA9928-19-7	1	0	0
150-Small Fab	92994A402	1	10 GAOSS	0
	BA9935	1	0	0
	-1	1	10	0



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Container No: S097055



Part: RBA9928-19

Job No: 177145

Serial No/Batch: S097055

Revision: 5A

Inspector:

Exp Date:

Instructions:

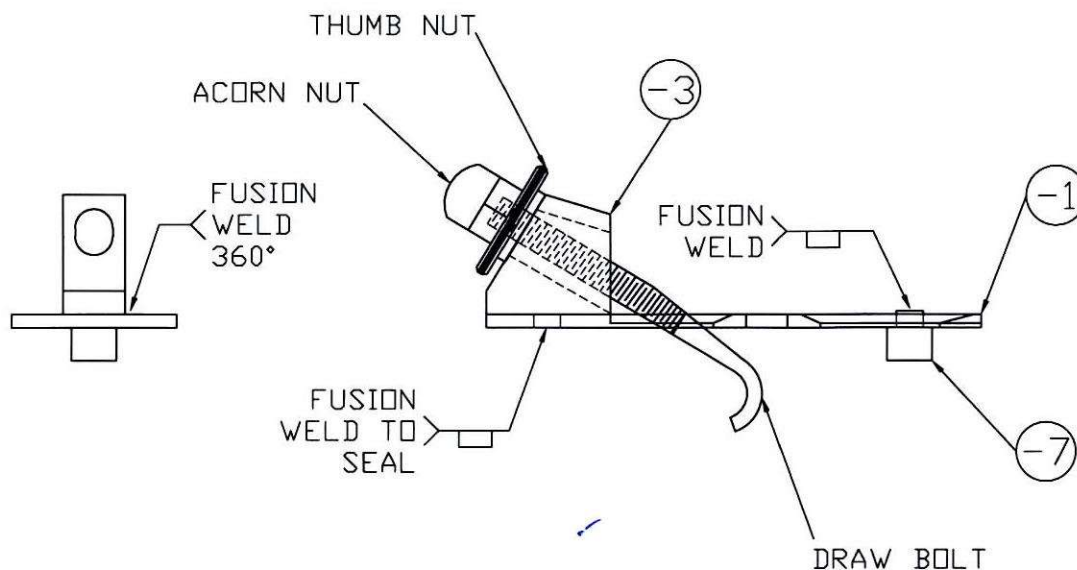
Part Specifications

Specifications could not be found.

Plex 6/21/18 10:15 AM dart.logan.david

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CH'D BUTTON, BUTTON NOW WELDED, RIVET ELIMINATED.	4/29/02	-	-
2	GRIND ON BUTTON WELD ELIMINATED.	11/26/02	-	-
3	MATERIAL CH'D TO STAINLESS STEEL P/N -1, -3, -7.	7/28/04	-	-
4	DELETED UNASSOCIATED .330 MEASUREMENT FROM X-REF. P/N -3.	11-21-06	-	-
5	CH'D ENGRAVE, ADDED FAR SIDE ENGRAVE S/N, "MADE IN USA".	4/30/09	-	-
5A	CH'D TITLEBLOCK & REVISION BLOCK, ADDED DRAW BOLT, THUMB NUT, & ACORN NUT TO ASSY. VIEW, CH'D REVISIONS TO NUMERICAL.	8/14/09	RJC	-



ASSEMBLY

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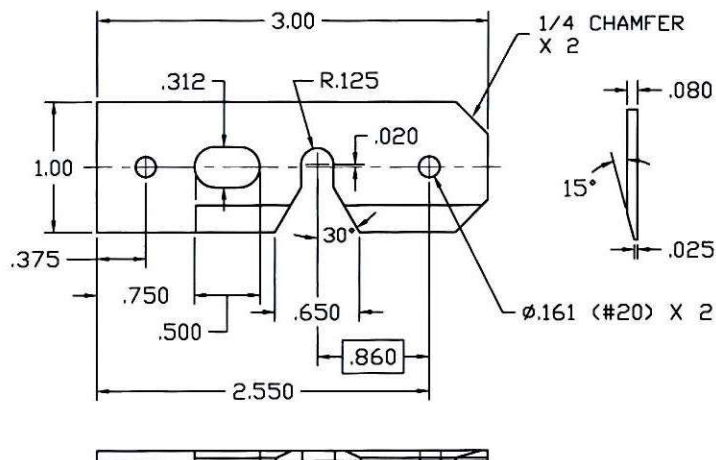
*SAME PART USED ON OTHER RIGGING TOOLS

ASSY QTY	ASSY QTY	B/D	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/D INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	PLATE	S.S.	.080 x 1 x 3	2
			-3*	1	LUG	S.S.	5/8 x 3/4 x 3/4	2
			-7*	1	BUTTON	S.S.	Ø.270 x .300	2
			RBA9935*	1	DRAW BOLT			1
		B/D		1	ACORN NUT	S.S.	10-32 UNF	1
		B/D		1	THUMB NUT	STEEL	10-32 UNF BLACK REID TOOL #V-1	1

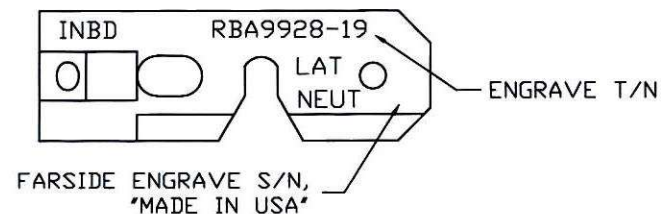
RED BARN MACHINE	
TITLE LATERAL RIGGING TOOL	
DWG NO. RBA9928-19	REV 5A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN BY: COLE
TOLERANCES ON DECIMALS	APPROVED
.XXX ± .005	HECK
.XX ± .01	FINISH SPEC
X ± .1	
FRACTIONS ± 1/32	
ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED	USED ON MODEL
1. BREAK ALL SHARP EDGES	MD 500
.015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 4-19-02
	SHEET 1 of 2

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	CH'D BUTTON, BUTTON NOW WELDED, RIVET ELIMINATED.	4/29/02	-
2	GRIND ON BUTTON WELD ELIMINATED.	11/26/02	-
4	DELETED UNASSOCIATED .330 MEASUREMENT FROM X-REF. P/N -3.	11-21-06	-



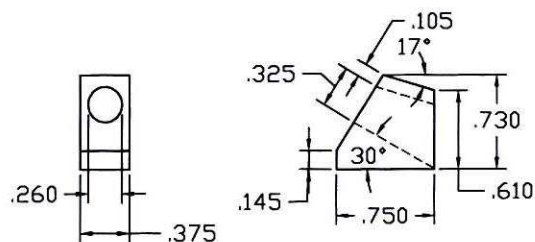
(-1)
PLATE



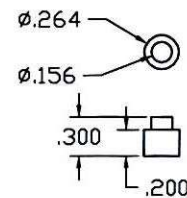
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20180621

7L



(-3)
LUG



(-7)
BUTTON

RED BARN MACHINE	
TITLE LATERAL RIGGING TOOL	
DWG NO. RBA9928-19-1 thru -7	REV 5A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	FRACTIONS ± 1/32 ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 4-19-02
SHEET 2 of 2	